Work Order II Monday, February 07,											Page 1
Item ID: D329 Revision ID: Item Name: Door Start Date: 2/8/2	Panel		Accept	Cust Item				Setup	Start Stop	1 18811181 811	
Required Date: 2/22/ Reference:				Customer							:(18 (81 (18) 18B4
	cess Plan:	Date: <u>//-02-07</u>	Tooling: SPC (Y/N):		Date:			Run	Start Stop	1 18011101 68	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr D3296	Revision Nbr Rev A										
Waterjet FLOW CNC Waterjet  >>>4 . ds3	FLOW WATER JET  Memo 1-Cut as per Deburr if ne	Dwg D3296 □Dwg Rev:	0.00 0.00 ▲ □Prog Rev:	<b>A</b> □2-			18.11	- 2-1	7_		<u> </u>
110 QC Quality Control	QC2- Inspect parts off m  Memo	achine FAI/FAIB	0.00				KBi	1-8-1	<u>17</u>		
120 QC	QC8- Inspect parts - seco	and check	0.00				m	1	1	02	17 (1

Quality Control

Dart Aerospa	ace Ltd
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W/O:			WO	RK ORDER CHANG	ES	γ-			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
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DATE	OTED	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	1 000	ion C	Chief Eng	QC Inspector
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#### Work Order ID 66191

Monday, February 07, 2011 11:56:23 AM



1

Page 2

Item ID:

D3296-3

Accept

Setup Start



**Revision ID:** 

Item Name: **Start Date:** 

Door Panel

2/8/2011

Start Qty: 6.00

**Req'd Qty:** 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Required Date: 2/22/2011

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Process Plan: \_\_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Run

Code

Start

Stop



QC:

Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

Date:

Stop



Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation

Description

Small Fab

Memo Deburr

**Run Hours** 0.00

0.00

**Tool ID** Tool # Plan

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

1811-2-17

140

HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

0.00

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Memo

6 BR 11-02-22

0.00

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W/O:				RK ORDER CHANG		D-4-	04.	Approval	Approval
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	Re	esolution:	Disposition	:	QA: N/C	Closed: _		Date: _	
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		Description of NC			ction B	Veri	fication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& ∣ <sub>Se</sub>	ction C	Chief Eng	QC Inspector
			1						

#### Work Order ID 66191

Monday, February 07, 2011 11:56:23 AM



Page 3

Item ID:

D3296-3

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Required Date: 2/22/2011

Door Panel

2/8/2011

QC:

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_ Date:

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool # Plan

Code

Date:

Start

Reject

Run

Accept

Qty



Number Stamp

Stop

Reject

Insp.

Sequence ID/

**Work Center ID** 

160

170

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 196

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

QC Quality Control

Memo

0.00

0.00

<b>Dart Aerospace</b>	L	_td	
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Da	ite Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC			ion B	, ,	/erification	Approval	Approval
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### **Picklist Print**

Monday, February 07, 2011 11:56:21 AM

Work Order ID: 66191

Parent Item:

D3296-3

Parent Item Name: Door Panel



**Start Date: 2/8/2011** 

Required Date: 2/22/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP  $C \square 05.10.14 \square Added step 14 \square KJ/EC$ 

IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	31.9270	0.6532	4.125474			
										ŧ	811-2	-17	

2024-T3 .063 sheet

<b>Location</b>	Loc Qty	Loc Code		Δ
MAT22	31.927			ζ
114351	31.927		114351	C

Dart .	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CHANGE	ES				
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	ł)			
DATE	STEP	Description of NC		Corrective Action Section	on B Sign 8		cation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	66191
Description: Door Panel	Part Number:	D3296-3
Inspection Dwg: D3296 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

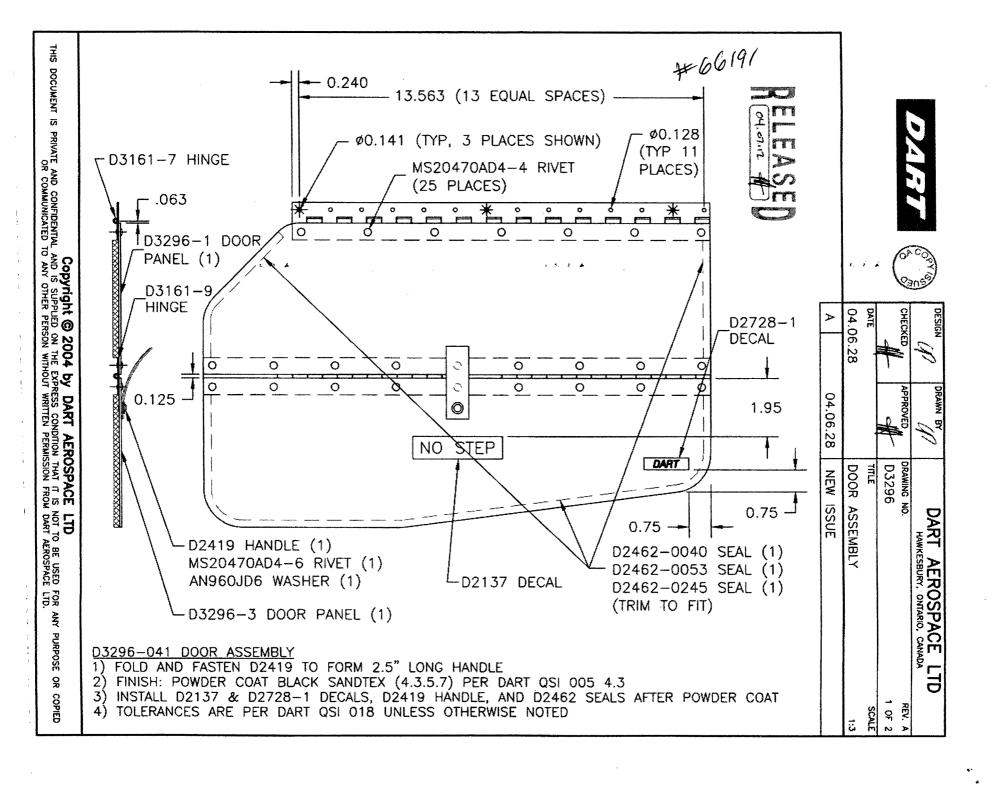
	X	First Arti	cle	Prote	otype
wing		Actual			Method

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension	-			
5.03	+/-0.030	5,039	*		V BOZ	
R0.060	+/-0.010	,060	P		R.G.	
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Measured by:	B	Audited by:	M·M	Prototype Approval:	N/A
Date:	11-6-11	Date:	11.02.17	Date:	N/A

Rev	Date	Change		Revised by	Approv <i>e</i> d
Α	04.08.24	New Issue	P/O D3296-041	KJ/JLM	
					7,0.7

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		esolution:	Disposition: Q			QA: N/C Closed: Date:			
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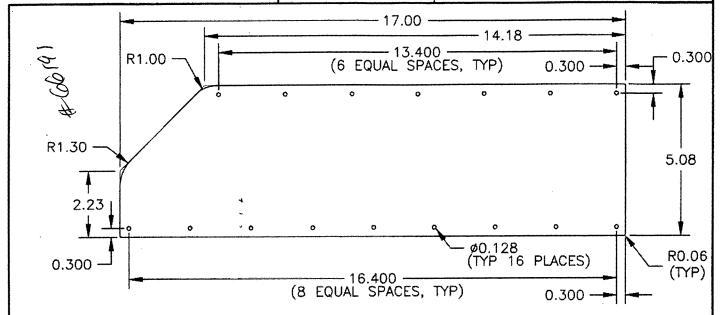


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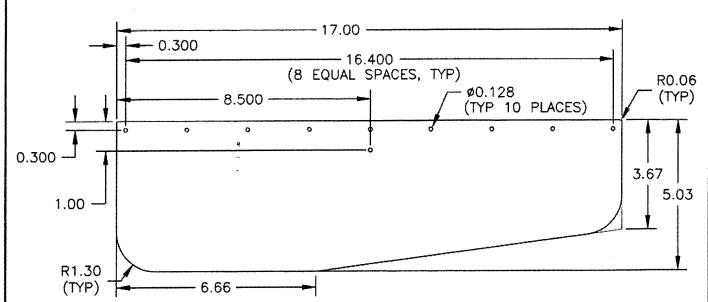




DESIGN (	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHECKED	APPROVED	DRAWING NO.	REV. A
#	<del>-</del> # -	D3296	2 OF 2
DATE		TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3



#### D3296-1 DOOR PANEL



#### D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF DART SPEC. M2024T3S.063)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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